



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-589-041
Job Sheet 168967



CHG004

Part No: D350-589-041

Job Qty: 1 ea

Part Name: Side Door Assembly - LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/28/17

Job Tracking No:

Due Date: 12/8/17

Created By: Linda Lacelle

Type: SOLD

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Note: D2991 REV E , IIN-D350-589 REV E IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC IPP rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD IPP Rev:D add seq 103/105 DD 10.03.17 verified by:JLM IPP Rev:E add DSI's DD 10.03.29 verified by:EC IPP Rev:F add seq 103/105 DD 10.05.10 verified :EC IPP Rev:G 10.10.13 PER ECN10-576 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/8/17	12/8/17	0.00	0.00	Start Up Small Fab-4		
140	Packaging	1 pcs	12/8/17	12/8/17	0.00	0.00	Packaging1		
150	QC	1 pcs	12/8/17	12/8/17	0.00	0.00	QC4		
160	DC	1 pcs	12/8/17	12/8/17	0.00	0.00	DC		
170	Packaging	1 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea	12/8/17	12/8/17	0.00	0.00	QC21		

Part Op 160 - Photocopy bluefile & type labels per PPP D350-589-041 CHG006
Descriptions: 170 - Identify and pack for shipping as per PPP D350-589-041 Location: FG070

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2464-4700	1	0	0	0
	D2585	3	23	0	0
	D2586	3	30	0	0
	D2624	3	8	0	0
	D2991-1	1	1	0	0
	D3085-041	1	2	0	0
	MS21042L3	3	889	0	0
	MS27039-1-18	3	522	0	0
	NAS1149D0803J	3	203	0	0
	AN3-4A	6	256	0	0
140-Packaging	D2237	3	20	0	0
	D2589	1	11	0	0
	MS20470AD4-5	6	988	0	0
	MS21042L3	6	889	0	0
		6		0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Rejected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date : _____				QTY Effective : _____			MRB (QSI042) Approval		
Description				Disposition			Completed By		
Job No: 168967 Mfg Date: 01/18/18 CHG006 Packaging Operation No: _____ Revision: _____ Original Serial #: S033577 D350-589-041 PART NO: _____ Side Door Assembly - LH Barcode: S033577 DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root									
Environment	☐	Offset/Setup	☐	Cracks	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Supplier	☐	Crimp/Kink/Ripple/Wave	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Training	☐	Cuffs	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Use for Testing	☐	Crushing	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Poor Information	☐	Heat Treat	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Rushing	☐	Wave/Twist in Tube	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Product Improvement	☐	Marks/Chatter	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Process Improvement	☐		☐	Mislabeled	☐	Finish	☐
LOA	☐	Manufacturing Process	☐		☐	Fit/Function	☐	Misread	☐
Substation	☐	Past Due	☐		☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐		☐	OTHER :					
Misidentified	☐		☐						

Part Specifications

Specifications could not be found.

Plex 11/28/17 8:52 AM dart.lacelle.linda

DART Dart Aerospace Ltd. 1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P.N.	D350-589-041	CHG	CHG004		
DESC.	Side Door Assembly, LH	STC	SH92-41		
LOT	B52500	STC	SH1012NE		
MODEL	AS350	STC			
MADE IN CANADA					
D3729-1					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ORDER ACKNOWLEDGEMENT

CUSTOMER					ORDER				
Customer Code: CHELI02 Sold To: Heliswiss Iberica SA Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona 08205 Sabadell Spain Phone: +46 (0)973-10245 Fax: 34-937-100130 Ship To: FISKFLYG AB Strömgatan 43 98260 Porjus Sweden					Order No : 1563 Date: 11/27/17 Ship-To Contact: Stina Kallin Email: teknik@fiskflyg.se Cust PO No: 1700795 FOB: Shipping Point Ship Via: TNT Collect Freight Terms: Third Party Billing Terms: Net 30 INCO Terms: Ex Works Order Taker: Kinga Lysiak Order Taker Phone: Order Taker Email: klysiak@dartaero.com				

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	12/18/17	12/18/17	D350-589-041	Side Door Assembly - LH 3 weeks HBY	1	pcs	\$6,305.00USD	pcs	\$6,305.00 USD
				25% Discount Distributor			-25.00		\$-1,576.25
								Sub Total	\$4,728.75 USD
								Grand Total	\$4,728.75 USD

ORDER NOTES

Customer Forwarder: TNT
 Account Number: 2002410
 Instructions: "Economy shipment is enough"
 Custom Clearance To Be Billed To Receiver
 Duties & Taxes To Be Billed To Receiver
 Ship Order As Soon As Possible
 Ship Order Complete
 Use Unit/List Price On Shipping Documents

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

Plex 11/27/17 9:23 AM dart.lysiak.kinga

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Linda Lacelle

From: David Duval
Sent: Tuesday, November 28, 2017 8:47 AM
To: Linda Lacelle; Daniel Paquette
Cc: Mario Poulin
Subject: RE: order 1563 FISKFLYG AB/ Heliswiss

done

DAVID DUVAL
Production Engineering Supervisor

From: Linda Lacelle
Sent: November-27-17 5:01 PM
To: David Duval <dduval@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>
Cc: Mario Poulin <mpoulin@dartaero.com>
Subject: Re: order 1563 FISKFLYG AB/ Heliswiss

guys
pls let me know when this bom and route is done...

Thx
L

From: Linda Lacelle
Sent: Monday, November 27, 2017 9:28:49 AM
To: David Duval; Daniel Paquette
Cc: Mario Poulin
Subject: FW: order 1563 FISKFLYG AB/ Heliswiss

Need route and bom pls- D350-689-041

From: Kinga Lysiak
Sent: Monday, November 27, 2017 9:26 AM
To: Linda Lacelle <llacelle@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Mario Poulin <mpoulin@dartaero.com>
Cc: Sylvie Larocque <slarocque@dartaero.com>; Lewis Brooks <lbrooks@dartaero.com>
Subject: order 1563 FISKFLYG AB/ Heliswiss

Hi All

Please find the attached order to process
Thank you

Best regards,
Kinga Lysiak
Inside Sales Representative
EMEA, Russia & CIS

DART AEROSPACE
DART AEROSPACE
1 Bell Street, G01
Maidenhead
Berkshire, UK
SL6 1BU
M +44 (0) 7828775275
E klvslak@dartaero.com
www.dartaerospace.com



Linda Lacelle

From: Chris Provencal
Sent: Thursday, December 14, 2017 10:27 AM
To: Linda Lacelle; Eric Downing
Cc: Jason Leroux
Subject: RE: D2991-1 - D350-589-041

Linda,

D350-589-041 CHG 004 B52500 is acceptable to ship. It must ship as CHG 004 and **DSI 9463 Rev. A** (in 589 product specifications as on-request only) must be included in the paperwork. The door is CHG 004 and the design has went through several changes (currently CHG 006). However, based on ECNs 09-688 & 10-576, previous CHG numbers were acceptable to ship as-is.

The door may have a compatibility issue with the drip nozzle on the auxiliary fuel tank (D350-794). CHG 006 moved the strut to eliminate this problem. We may want to ask the customer/sales if he has the D350-794 tank. Ultimately, compatibility is the responsibility of the installer.

Note relevant to you (just including this observation in email record): I inspected B52500 and it has the wider hinge plates of D2991 Rev. D that addresses a possible a/c hinge compatibility issue.

Chris

From: Linda Lacelle
Sent: Wednesday, December 13, 2017 12:41 PM
To: Chris Provencal <cprovencal@dartaero.com>; Eric Downing <edowning@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>
Subject: RE: D2991-1 - D350-589-041

Ok, so how long will this take? I need to let the customer know

From: Chris Provencal
Sent: Wednesday, December 13, 2017 12:38 PM
To: Linda Lacelle <llacelle@dartaero.com>; Eric Downing <edowning@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>
Subject: RE: D2991-1 - D350-589-041

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

I have the DSI, but I need to review the changes since the door was made and determine if it's still OK.

Chris

From: Linda Lacelle
Sent: Wednesday, December 13, 2017 12:01 PM
To: Eric Downing <edowning@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>
Subject: RE: D2991-1 - D350-589-041

There are 3 latches on it, and Chris was going to check if this was ok, there is no DSI I can find that has 3 latches, but I remember this being added sometime wayyyyyyyyy back

From: Eric Downing
Sent: Wednesday, December 13, 2017 11:49 AM
To: Linda Lacelle <llacelle@dartaero.com>; Chris Provencal <cprovencal@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>
Subject: RE: D2991-1 - D350-589-041

Linda,

What's the matter with the doors we have in stock?

Eric

From: Linda Lacelle
Sent: Wednesday, December 13, 2017 11:38 AM
To: Chris Provencal <cprovencal@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; Eric Downing <edowning@dartaero.com>
Subject: D2991-1 - D350-589-041
Importance: High

Chris,
I need an answer for this- this shipment has to leave on Friday..... is the door we have good????

Thx
L

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

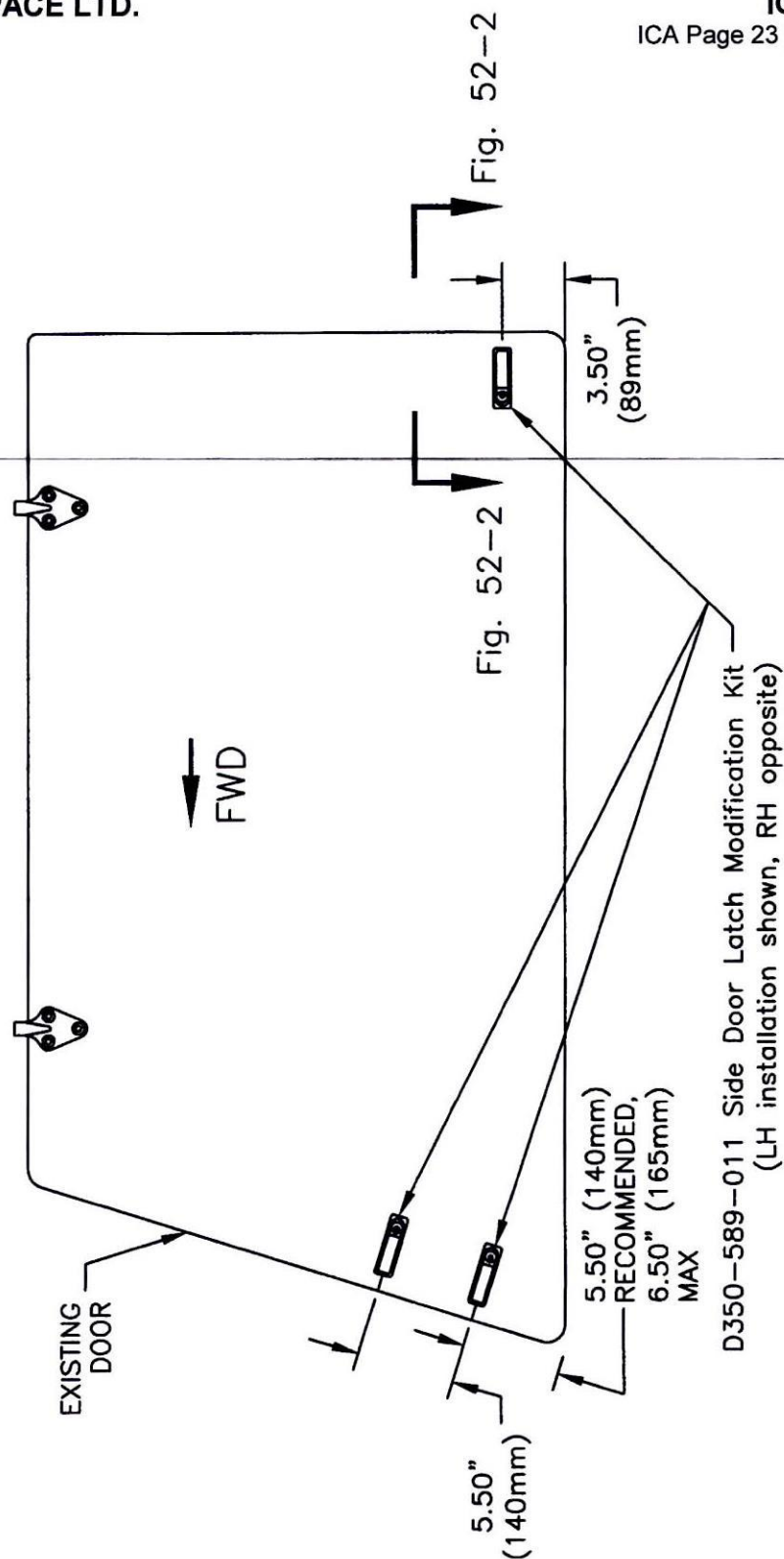


Figure 52-1: Typical D350-589-011 Side Door Latch Modification Kit

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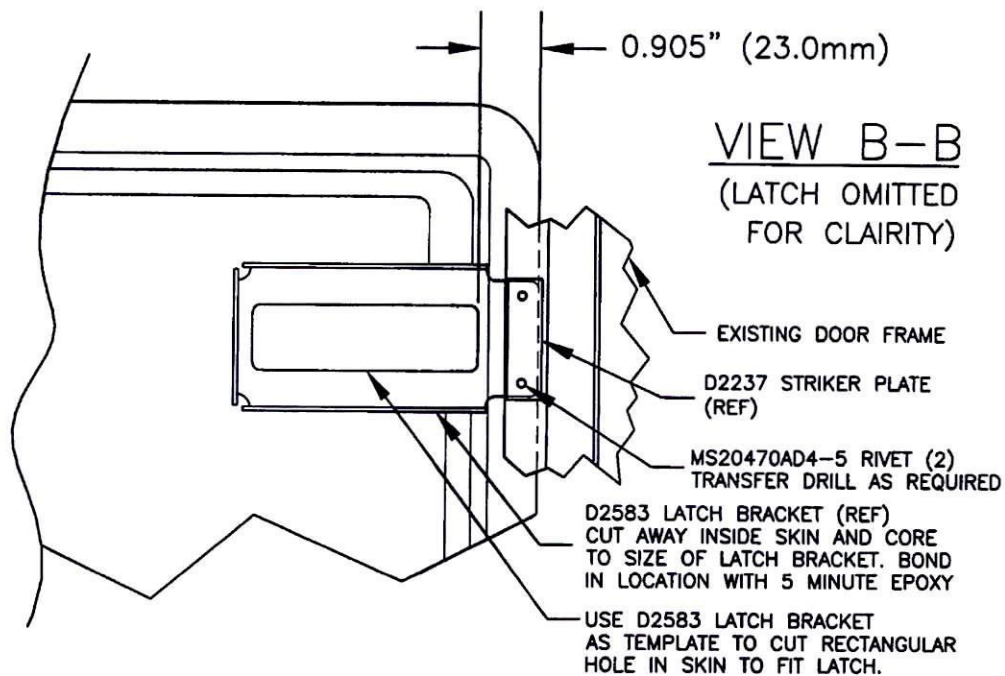
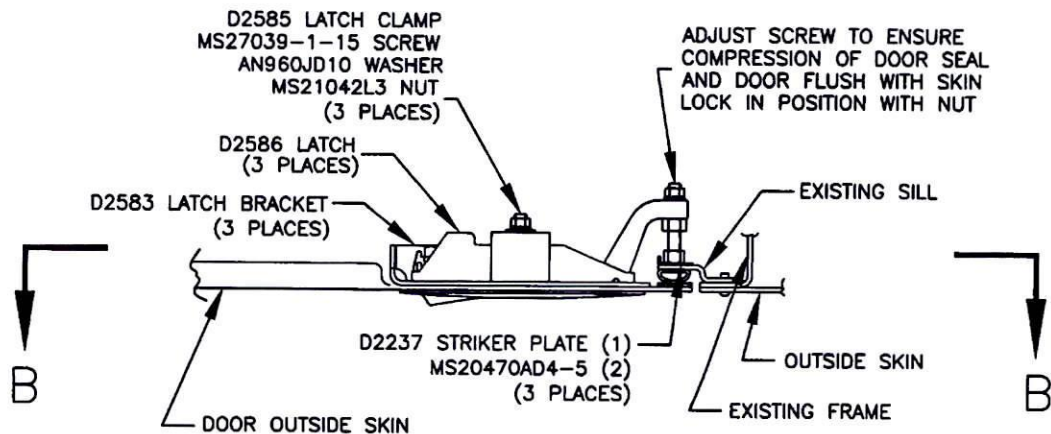


Figure 52-2: Typical Latch Bracket Installation

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52-00-00

Change Record

PAGE 1 OF 1

Part Number: D350-589-041

Description: SIDE DOOR ASSEMBLY, LH (AS 350)

[illegible]